

Work Order ID 82721

82721

Page 1

Thursday, April 05, 2012 12:57:19 PM

Item ID: D3262-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 4/5/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/13/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *P* Date: *12-04-15* Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3262	E

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 6.000" x 0.500" x 5.400" long Bar								

25 *12-04-19* *(x4)*

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per dwg D3262 Machine as per Folio FA902 and Dwg D3262 FOLIO REV: <u><i>AA</i></u> DWG REV: <u><i>E</i></u> TAP USING JIG DT9636 Deburr								

6 *φ* *12/04/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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82721

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Item ID: D3262-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 4/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/4/23

1201-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 12:57:23 PM

Page 1

Work Order ID: 82721

82721

Parent Item: D3262-5

D3262-5

Parent Item Name: Cap

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased		No		100	f	22.0760	0.96	6.063158			

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

**

12-64-19

Location

Loc Qty

Loc Code

MAT004

22.076

112567

9.15

115045

0.926

120243

12

x 6.063158

9260

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DART AEROSPACE LTD		Work Order: 82721
Description: Cap		Part Number: D3262-5
Inspection Dwg: D3262	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	0.4425	✓		SLO8	Vern
0.25	+/-0.030	0.246	✓			
Ø0.875	+/-0.010	Ø0.875	✓			
Ø5.005	+0.010/-0.000	Ø5.007	✓			
R0.063	+/-0.010	R.0625	✓			
0.080	+/-0.010	0.079	✓			
0.13	+/-0.030	0.1285	✓			
0.070 x 45°	+/-0.010 x 0.5°	0.069 x 45°	✓			
Ø5.165 Ref	+/-0.010	Ø5.166	✓			
1.63	+/-0.030	1.6235	✓			
3.25 Ref	+/-0.030	3.247	✓			
9/16-18 UNF-3B	N/A	9/16-18 UNF	✓		Thread gauge	
3/4-16 UNF-3B	N/A	3/4-16 UNF	✓		Thread gauge	
0.091	+0.007/-0.008	0.095	✓		SLO8	Vern
R0.03	+/-0.010	R.03	✓			
R0.02	+0.00/-0.01	R.02	✓			
45°	+/-0.5°	45°	✓			
30°	+/-0.5°	30°	✓			
Ø0.588	+0.005/-0.000	Ø0.590	✓			
Ø0.696	+0.007/-0.008	Ø0.690	✓			
0.101	+0.008/-0.007	0.103	✓			
R0.03	+/-0.010	R.03	✓			
R0.02	+0.00/-0.01	R.02	✓			
45°	+/-0.5°	45°	✓			
30°	+/-0.5°	30°	✓			
Ø0.771	+0.005/-0.000	Ø0.773	✓			
Ø0.882	+0.008/-0.007	Ø0.881	✓			

Measured by: S.J.	Audited by: B.A.	Preliminary Approval:
Date: 12/04/21	Date: 12/04/23	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

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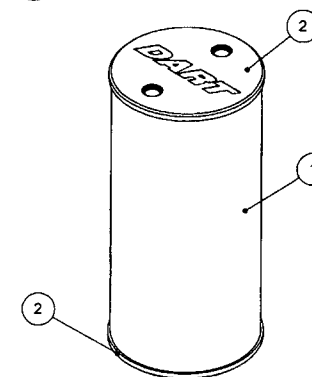
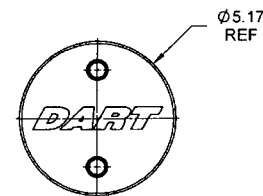
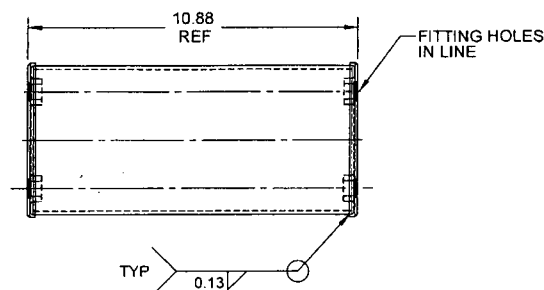
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82721 *R12-04-5*



D3262-041 CANISTER ASSEMBLY

RELEASED
2010-05-07
NA

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE	10.05.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3262** REV. E
SHEET 1 OF 5
TITLE **FUEL PURGE CANISTER** SCALE NTS

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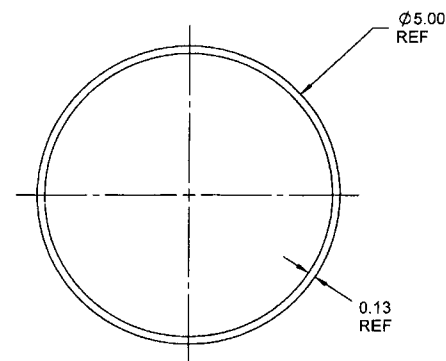
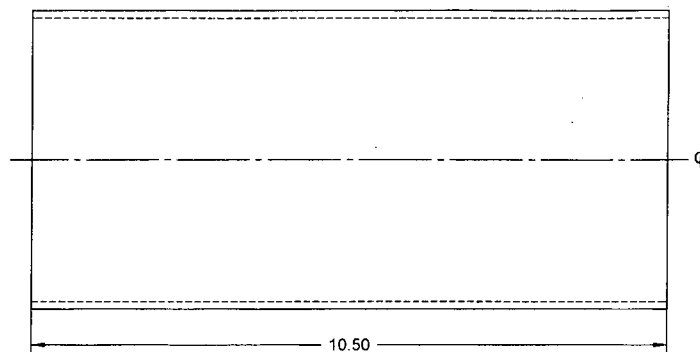
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NOTE: Date & initial all entries



D3262-1 TUBE

82721

RELEASED
2010-05-07
MM

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 3 OF 5
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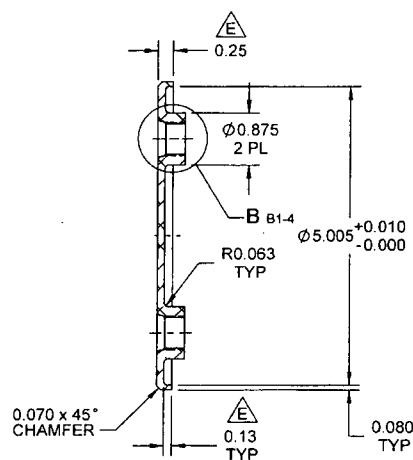
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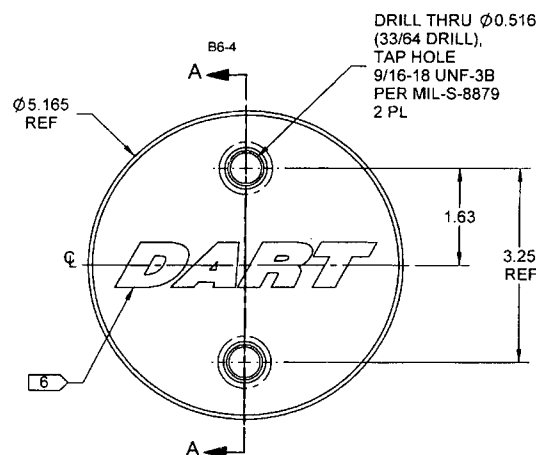
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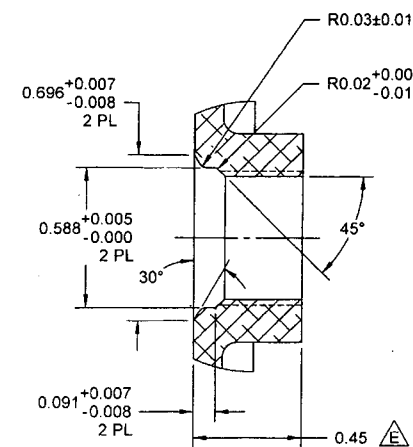
NOTE: Date & initial all entries



SECTION A-A C5-4



D3262-3 CAP



DETAIL B C7-4
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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2010-05-07
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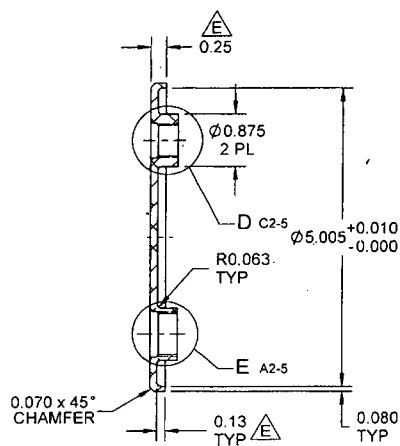
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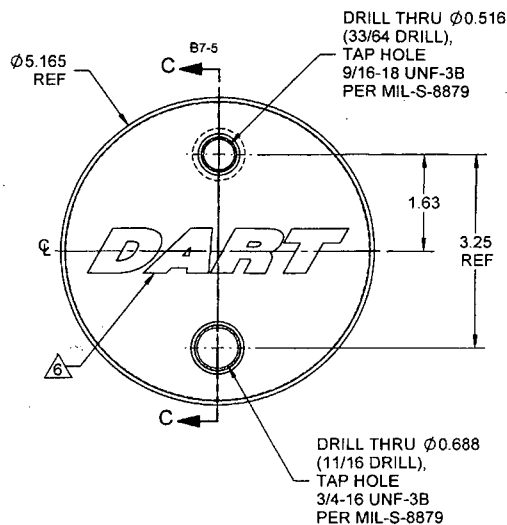
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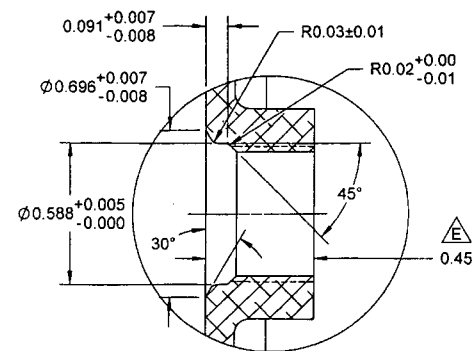
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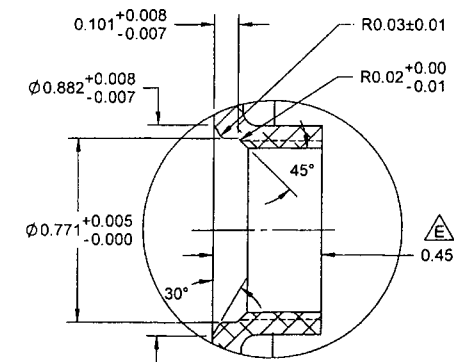
SECTION C-C D5-5



D3262-5 CAP



DETAIL D C7-5
SCALE 2X



DETAIL E B7-5
SCALE 2X

RELEASED
2010-05-07

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF: DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 5 OF 5
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